

43

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b>	18325
<b>Description:</b> Doubler		<b>Part Number:</b>	D2910
Drawing: D2910, Rev A		<b>Qty:</b>	24
		Multiples of 8	

Step	Location	Procedure	By	Date	Qty
1	EXPEDITING	Open W/O *Note: Issue W/O for D2911 & D2912 (same qty)	SP	02/10/21	24
2	METAL	Cut Blanks 13.80" x 5.60" Material: Sheet 6061-T6 x 0.091" thick Batch: <del>11131</del> M9131 1 blank makes one D2910 & one D2911 & one D2912	SP	02/10/22	24
3	METAL	Machine per folio FA033 CHECK FOLIO REV.	EC	02.10.22	24
4	QC	Inspect Level 2	EC	02.10.22	24
5	METAL	Tumble & Deburr	SP	02.10.24	24
6	METAL	Form on CNC brake as per Dwg D2910 & QSI 034 sec.4.1	SP	02.12.21	24
7	QC	Inspect Level 5	EC	02.12.19	24
8	METAL	Acid etch & Alodine per QSI-005	M	03.01.02	24
9	STORES	Identify & stock	Q	03.01.02	24
10	EXPEDITING	Close W/O Cost/part 5.14 595 03/01/03 24	A	03.01.03	-

Rev.	Date	Change	Revised By	Approved
A	00.04.25	New Issue	EC	

MATERIAL IS

ALREADY CUT.

02/08/15

RELEASED

EC 00.04.26

REFERENCE ONLY

# Job Costing Report

Dart Aerospace Ltd.  
Hawkesbury

Oct 21, 2002  
02:43 pm

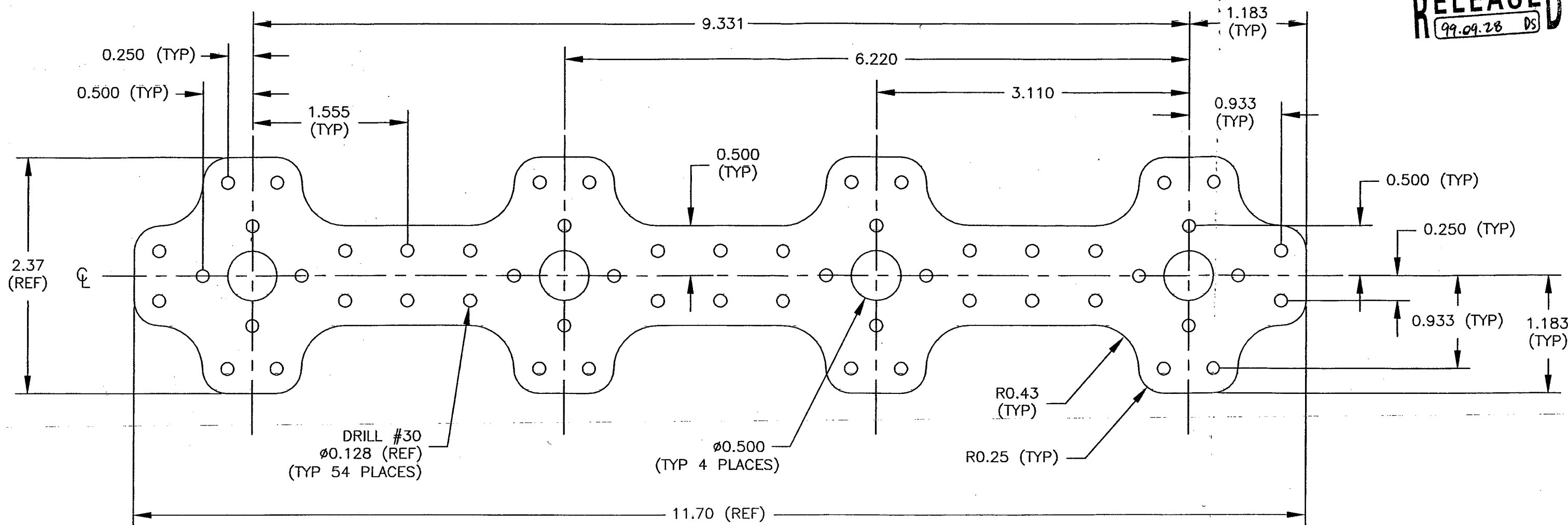
Work Order No	: 0018325	Department Code:	
Project Name	: D2910	Burden Flags	: NNNNNNN
Project For	: wk 43	WO Status	: Open
Work Order Type	: Main	Invoice State	: Not Invoiced
Main WO Number	:	Invoice Date	:
House Part Number	: D2910	Invoice Number	:
Description	: Doubler (Lama skid)	Invoice Amount	: 0.00
Manufactured	: Yes	Order Entry No	:
Amount Req'd	: 24	OE Value	: 0.00
Amount Done	: 0	Est Margin	: 0.000%
Start Date	:	Actual Margin	: 0.000%
Est Finish Date	: 10-22-02		
Act Finish Date	:		
Drawings Req'd	: No		
Ok for Approval	:		
Approval Rec'd	:		

\$0 Posted to Finished Goods

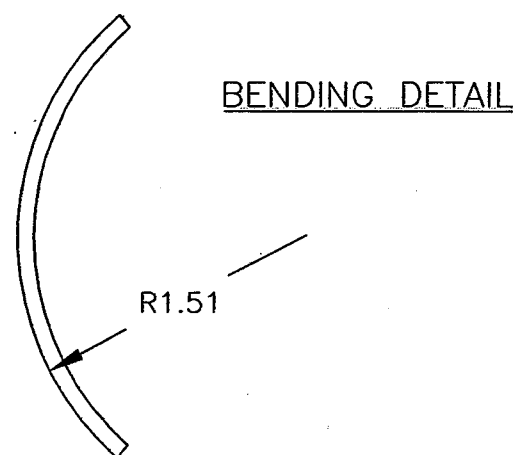
	Estimated	Actual	Var. %	Posted	To Post
Material Cost	0.00	0.00	0.00	0.00	0.00
Engineering Hours	0.00	0.00	0.00		
Engineering Cost	0.00	0.00	0.00	0.00	0.00
Production Hours	0.00	0.00	0.00		
Production Cost	0.00	0.00	0.00	0.00	0.00
Testing Hours	0.00	0.00	0.00		
Testing Cost	0.00	0.00	0.00	0.00	0.00
OverHead Hours	0.00	0.00	0.00		
OverHead Cost	0.00	0.00	0.00	0.00	0.00
SubContract Hours	0.00	0.00	0.00		
SubContract	0.00	0.00	0.00	0.00	0.00
Misc. Hours	0.00	0.00	0.00		
Misc.	0.00	0.00	0.00	0.00	0.00
Burden	0.00	0.00	0.00		
Total Cost	0.00	0.00	0.00		
Margin	0.000	0.000			
Selling Cost	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done	0.00	0.00
Profits/(Loss)	0.00	0.00

RELEASED  
99.09.28 DS



FLAT PATTERN



WORK ORDER  
NO. 18327

MATERIAL: 6061-T6 SHEET (QQ-A-250/11) 0.091" THICK  
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1  
BREAK ALL SHARP EDGES 0.010 TO 0.020  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
ALL DIMENSIONS ARE IN INCHES

A	99.09.07	NEW ISSUE
DESIGN CP	DRAWN BY RF	<b>DART</b> DART AEROSPACE USA, INC. BELLEVUE, WA
CHECKED CP	APPROVED [Signature]	DRAWING NO. D2910
DATE 99.09.07		TITLE DOUBLER
		REV. A SHEET 1 OF 1 SCALE 1:1



Dart Aerospace, Ltd  
1270 Aberdeen Street  
Hawksbury, Ontario  
K6A 1K7  
Tel: (613) 632-3336 Fax: (613) 632-4443

Sheet 1 of

## FIRST ARTICLE INSPECTION SHEET

PART NO.: D2910

DRAWING NO.: \_\_\_\_\_

DESCRIPTION: Doubler

DRAWING REVISION: \_\_\_\_\_

MANUFACTURING DATE: 02.10.23

EFFECTIVE DEO / DSI: \_\_\_\_\_

BATCH NO.: 18325

QUANTITY ACPT. \_\_\_\_\_ REJ. \_\_\_\_\_

Dim.	Min.	Max.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
A	2.360	2.380	2.372	✓				
B	0.495	0.505	0.501	✓				
C	0.490	0.510	0.500	✓				
D	11.690	11.710	11.700	✓				
E	9.326	9.336	9.330	✓				
F	6.215	6.225	6.223	✓				
G	3.105	3.115	3.113	✓				
H	φ.520	φ.505	φ.502	✓				
I								
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K								
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Y								
Z								

H:\admin-qaliso\forms\first article inspectionA

Measured by: EE  
Date: 02-10-24

Audited by: SP  
Date: 02-10-24

Approved by: UP  
Date: 02.10.24

Rev	Date	Created By	Approved
A			